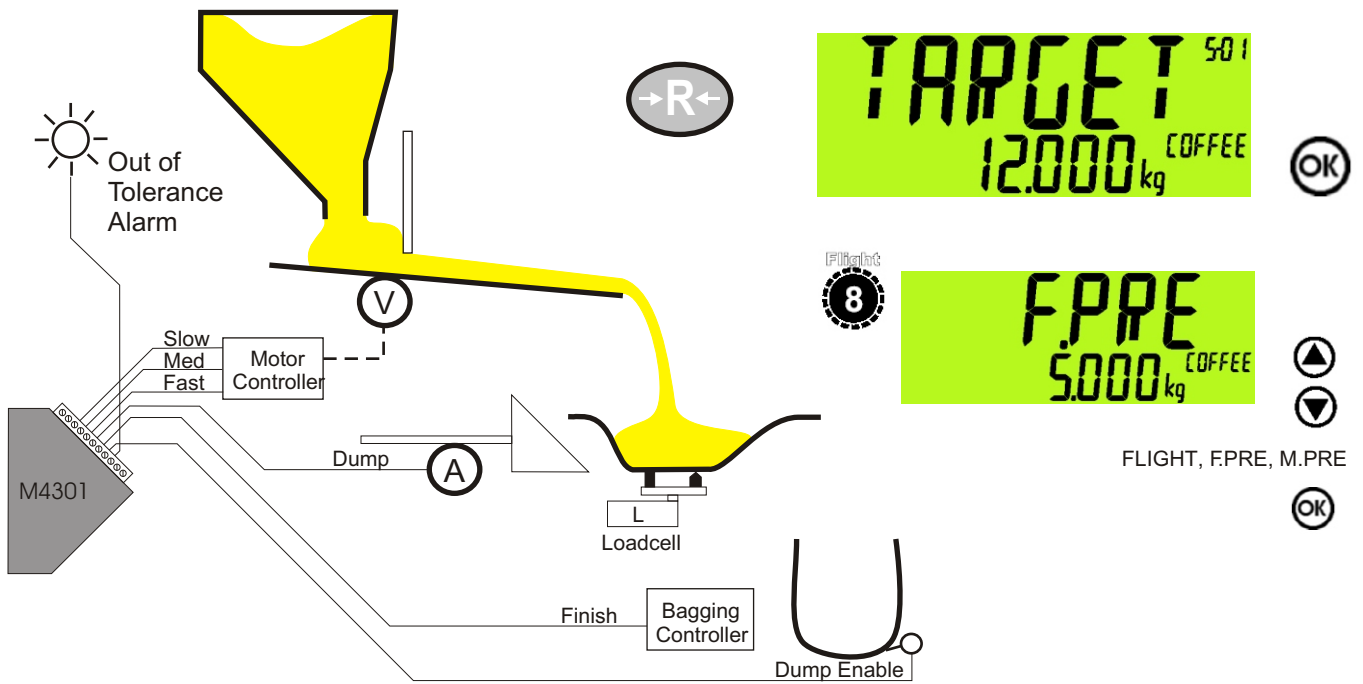




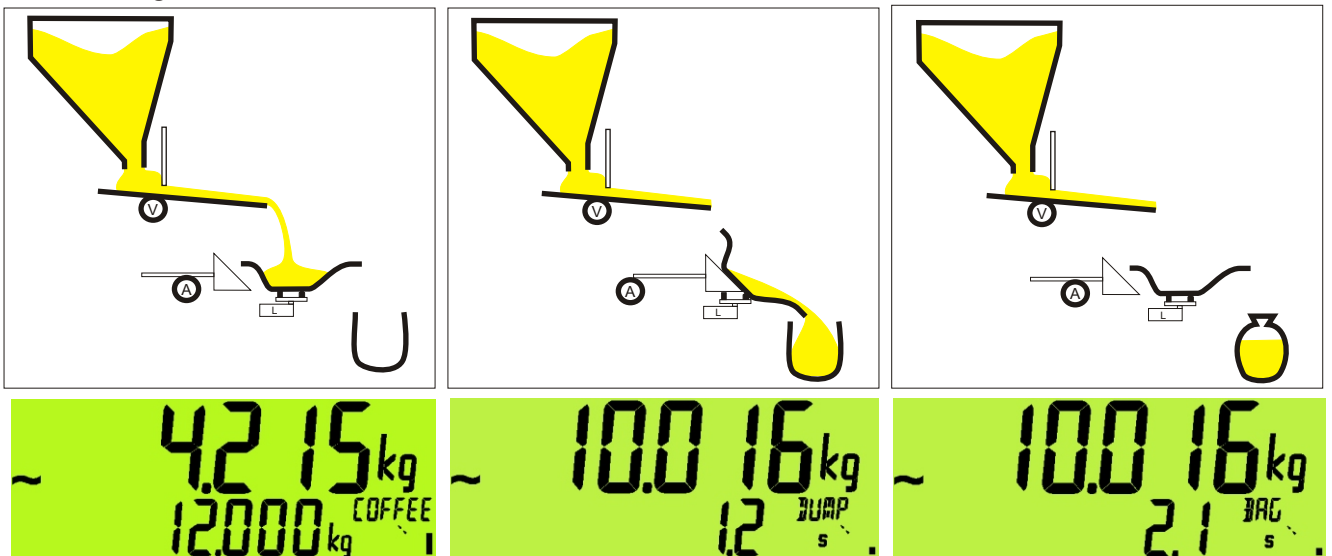
K411 App Note 1: Single Material Bag Filler



Stage 1: Fill

Stage 2: Dump

Stage 3: Pulse



Notes:

Multi-speed Filling stage ensures fast accurate filling.
 Auto-inflight correction is used to ensure filling accuracy is maintained as header tank empties and fill rate slows.

Dump-to-time is used instead of Dump-to-weight as the dump actuator in this application presses down on the loadcell and makes weight reading unreliable.

Dump Enable input is used to ensure that the downstream bagging system is ready for the dump with an empty bag in place.

The Pulse output signal is used by the bagging system as an acknowledgement that the bag is full and ready to close and dispatch.

```

SETUP
...
FUNC
  NUM      : _2_
  SF1
    TYPE   : START
  SF2
    TYPE   : PSE.ABT
  SETP
    NUM    : _1_
    SETP1
      TYPE  : TOL
      OUTPUT : IO7
  BATCH
    MAT
      NAME1 : COFFEE
      ...

```

```

SETUP
  BATCH
    STAGES
      NUM      : _3_
      STAGE.1
        TYPE   : FILL
        S.FILL : IO1
        M.FILL : IO2
        F.FILL : IO3
        ...
        MAT    : MAT.1
        ST.ACT : TARE
        CORR   : AUT.FLT
        ...

```

```

SETUP
  BATCH
    STAGES
      STAGE.2
        TYPE   : DUMP
        DMP.OUT : IO4
        ...
        ENABLE : IO6
        DMP.TYP : TIME
        ...
        PLS.TME : 1.5
        ...
      STAGE.3
        TYPE   : PULSE
        NAME   : BAG
        PLS.OUT : IO5
        ...

```

